

Date: Friday, 25/04/2008 12:49:02 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 38801	
Estimate Number : 13269	
P.O. Number :	Part Number : D323851
This Issue : 25/04/2008 S.O. No. :	Drawing Number : D3238 REV.D U/R
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : D U/R
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 02/05/2008 Qty: 2 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 08-04-18 DD verified by:EC	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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Comment: Qty.: 0.0292 f(s)/Unit Total : 0.0584 f(s)

6061T6 aluminum bar 0.250" X 6.00"

batch: 107130 HB 8-4-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: DProg Rev: DHB 8-4-28

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-4-28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SF 08/04/29 (3)

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: 1- Face mill as per dwg D3238

2-Deburr as per dwg D3238

28 08/04/29

(3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 38801

Part Number: D323851

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (48)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08-04-29 (3)

8.0

QC3

ENGINEERING INSPECT POWDER COAT/CHEMICAL CONVERSION

APPROVAL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 08-04-29 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

rayle

10.0

QC21

FINAL INSPECTION/W/O RELEASE

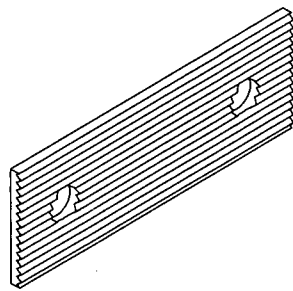


Comment: FINAL INSPECTION/W/O RELEASE

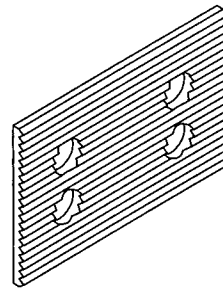
08/08/25 (48)

Job Completion

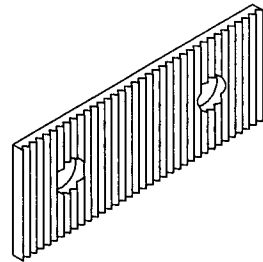
Charge to w/o 00220.
U 08/05/09



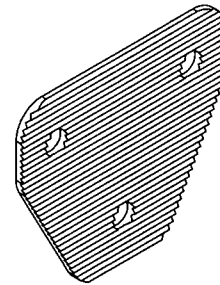
D3238-1 PLATE



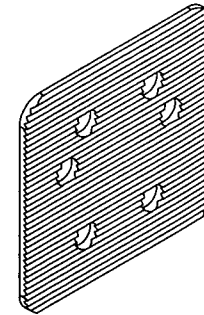
D3238-3 PLATE



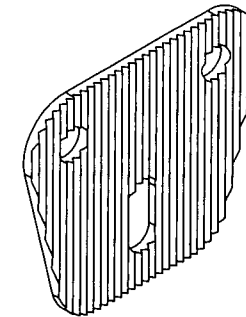
D3238-5 PLATE



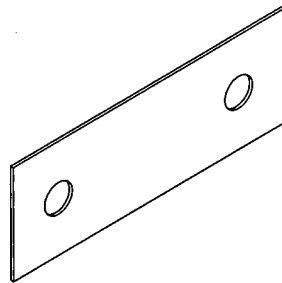
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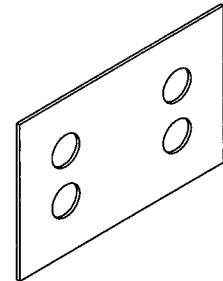
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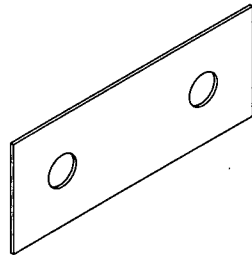
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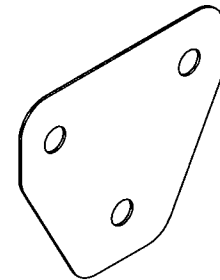
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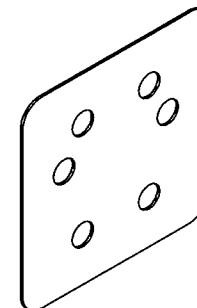
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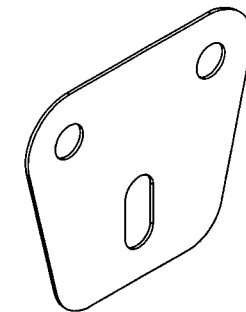
D3238-15 PLATE




D3238-31 PLATE



D3238-33 PLATE



D3238-35 PLATE



D3238-41/-51/-61 PLATE 
(SIMILAR)

D3238-45/-55 PLATE 
(SIMILAR)

NOTES:

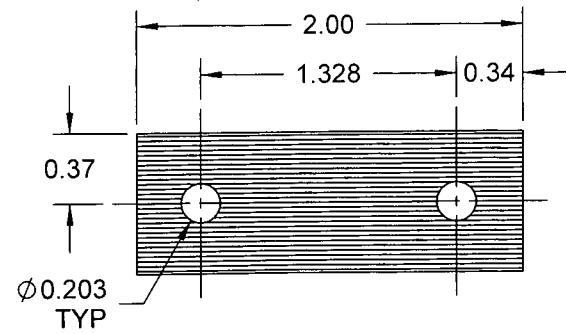
- 1) MATERIAL: -1/-3/-5/-21/-23/-25 PLATE:
2024-T3 ALUMINUM SHEET
PER QQ-A-250/4 OR AMS 4037
REF. DART SPEC M2024T3S
- 11/-13/-15/-31/-33/-35 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC M6061T6S.020
OR: 5032-H32 ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.020
- 41 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC M6061T6S.040
OR: 5032-H32 ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.040
- 45/-51/-55/-61 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)

NOTES (CONTINUED):

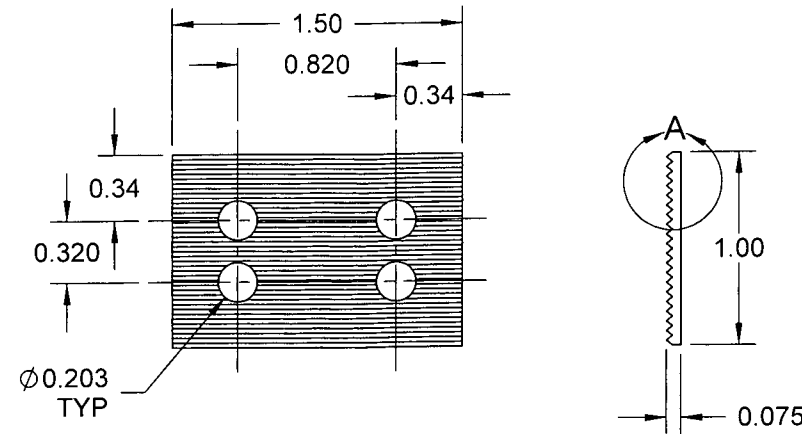
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) NOTE DELETED 
7) NOTE DELETED 
8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3238-X" USING FINE POINT PERMANENT INK MARKER
9) WEIGHT: 0.01 lbs APPROX

PROTOTYPE
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AJS 08.04.17

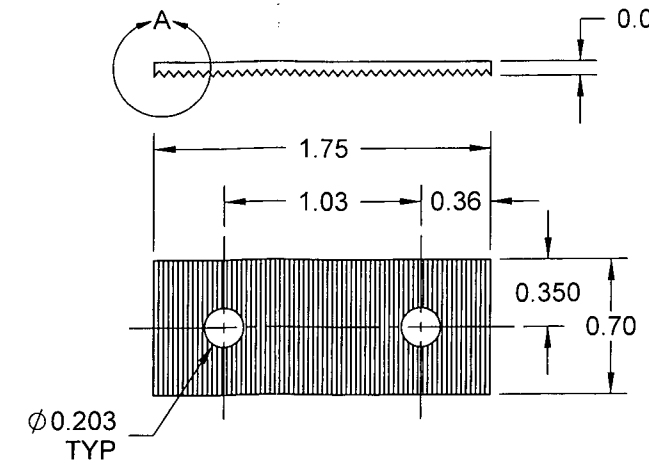
D	REDRAW TO SOLIDWORKS FORMAT. ADD -41/-45/-51/-55 & -61. DELETE NOTES 6 & 7.	AJS	08.04.02
C	ADD 5052-H32 OPTION	CB	07.02.19
B	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	CB	07.01.17
A	NEW ISSUE	CP	03.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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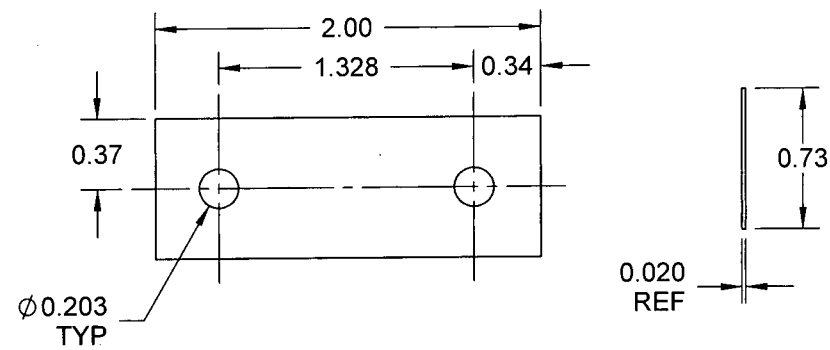
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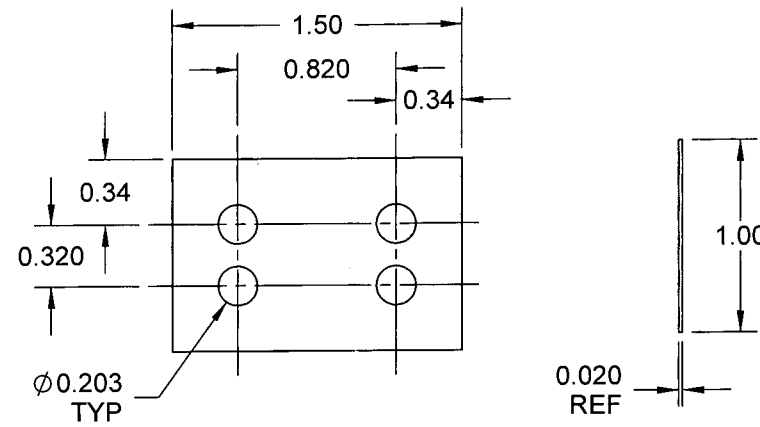
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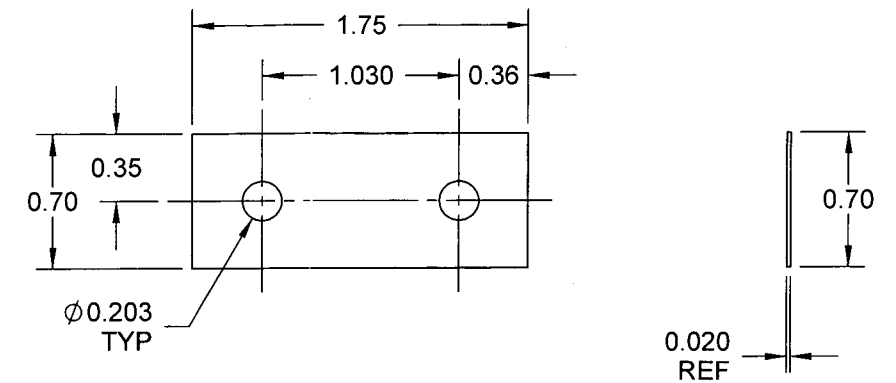
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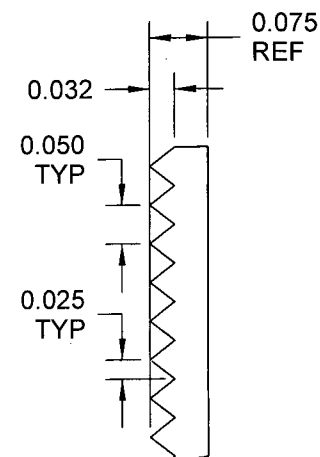
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D3238-13 PLATE



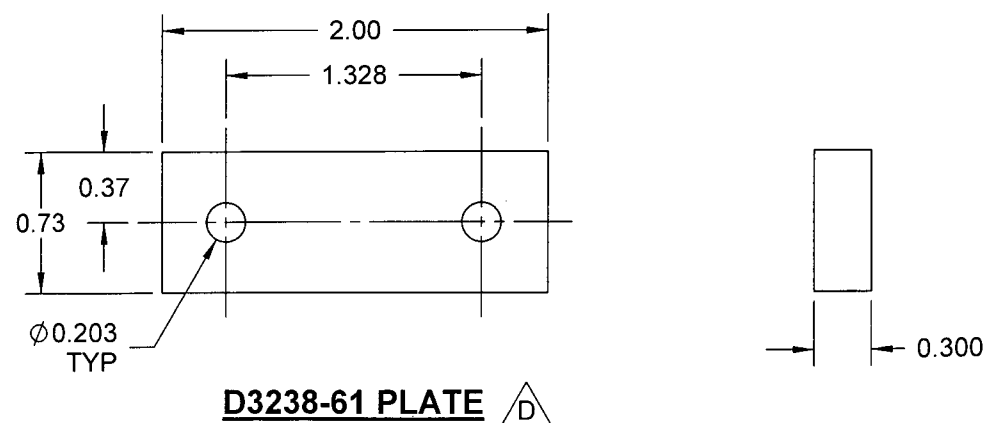
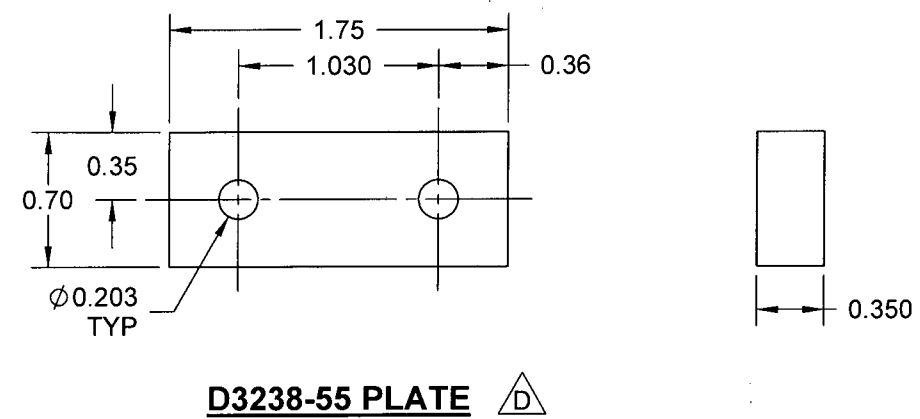
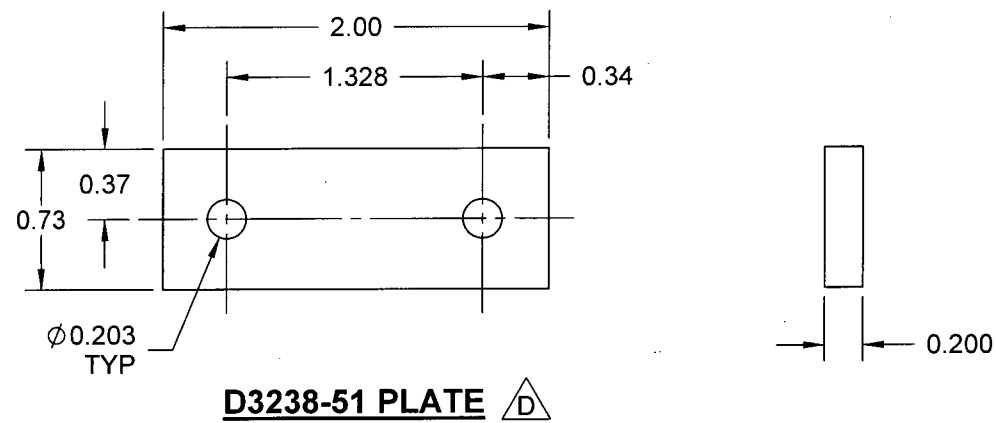
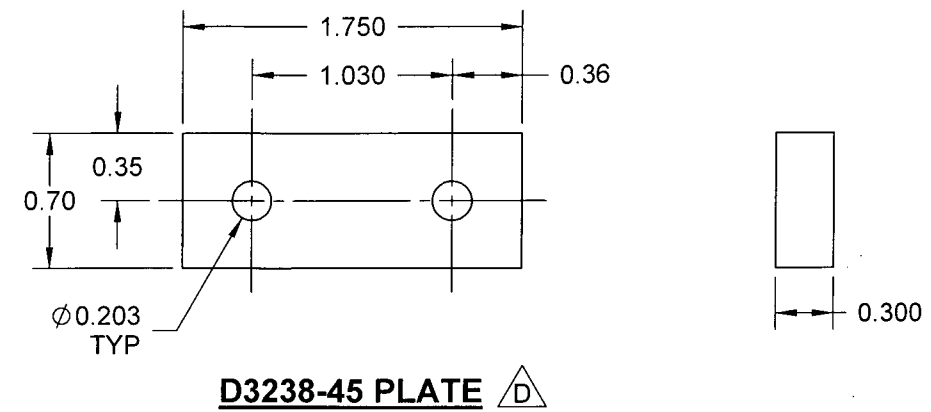
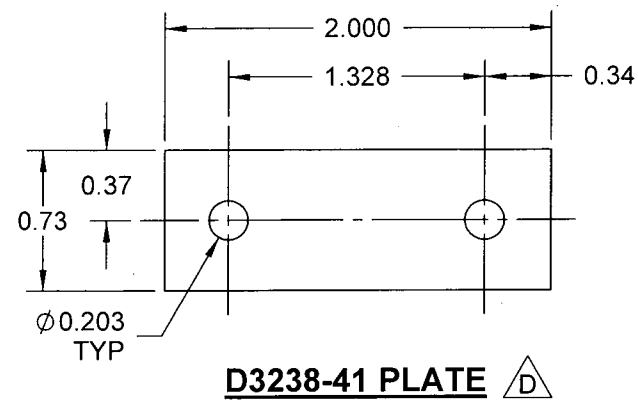
D3238-15 PLATE



**DETAIL A
SCALE 4X**

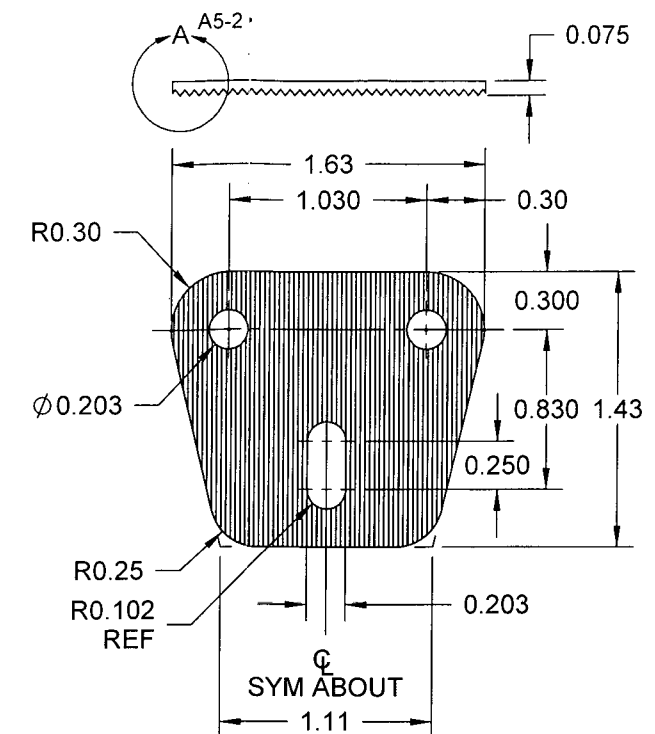
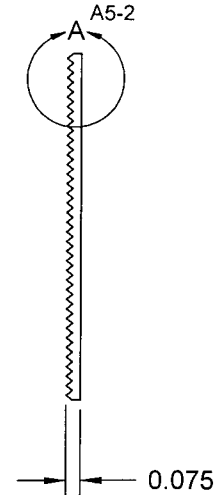
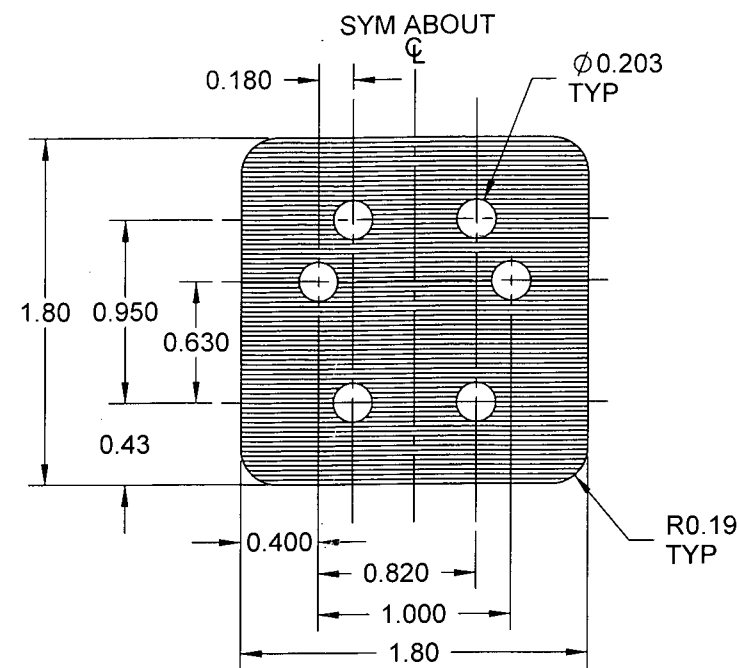
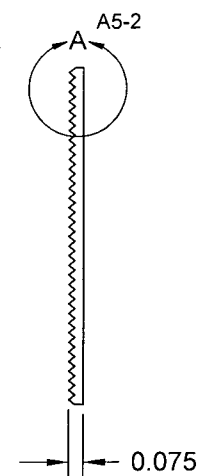
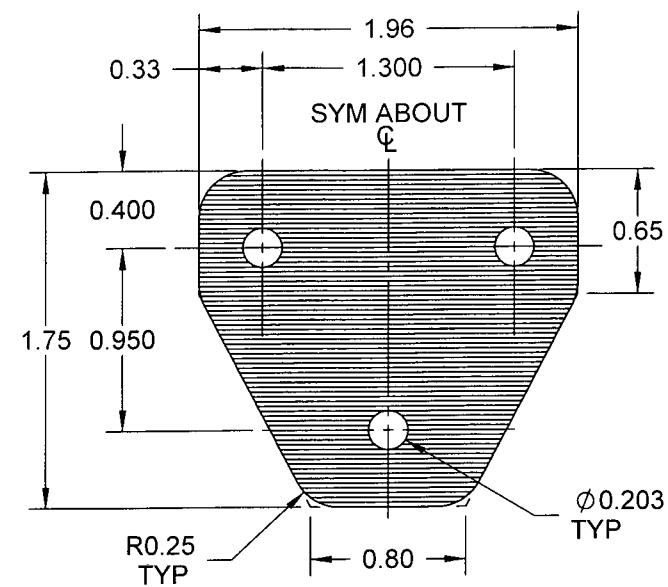
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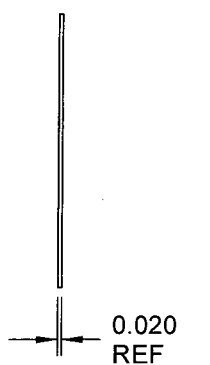
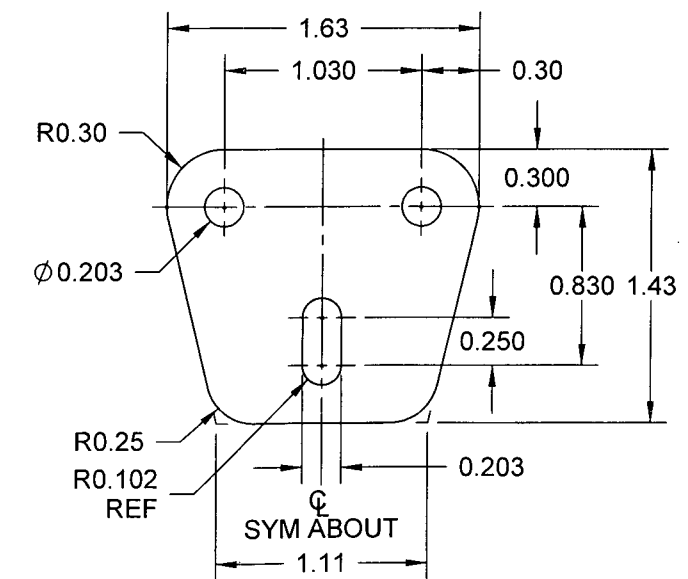
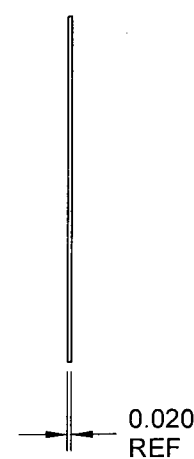
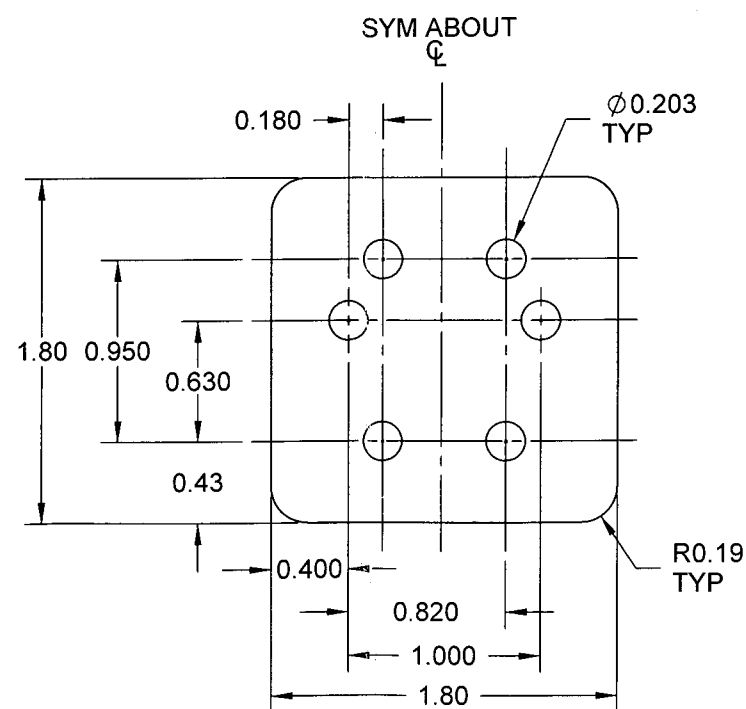
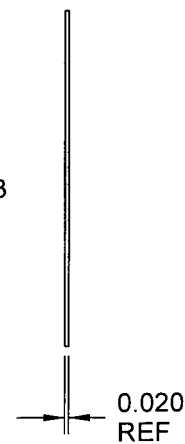
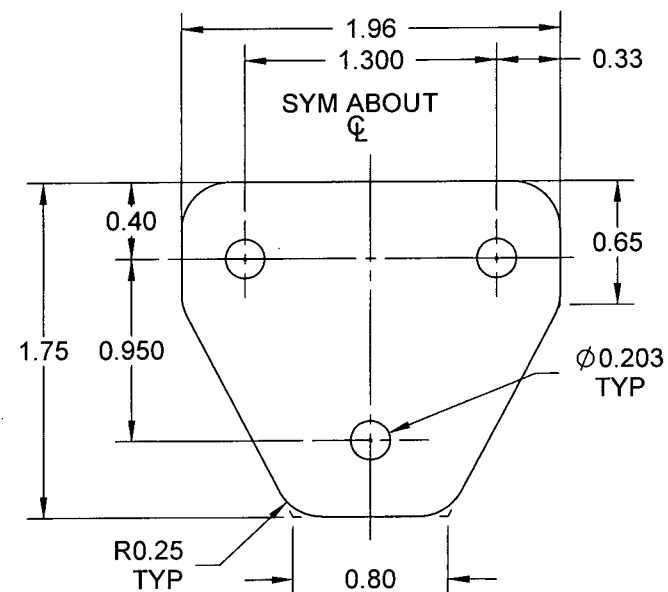


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